



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SK145-0114-20
Job Sheet 177227-A



Part No: SK145-0114-20

Job Qty: 10 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 5/18/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: IPP REV:A 17.06.06 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	QC	10 pcs		5/18/18	0.00	0.00	QC8 Machining-4		
142	HandFinish	10 pcs		5/18/18	0.00	0.74	HandFinish1		
144	QC	10 pcs		5/18/18	0.00	0.00	QC7-5		
146	Powdercoat	10 pcs		5/18/18	0.00	0.40	Powdercoat8		
148	QC	10 pcs		5/18/18	0.00	0.00	QC3		
150	Packaging	10 pcs		5/18/18	0.00	0.00	Packaging3-1		
160	QC21-SA	10 Ea		5/18/18	0.00	0.00	QC21		

Part Op 146 - ***Mask SK145-0114-25 prior to powdercoat** START TIME: 8:30 OVEN TEMPERATURE: 320°
Descriptions: FINISH TIME: 9:00 M 116309.

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 5/31/18 1:46 PM dart.lacelle.linda



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SK145-0114-20
Job Sheet 177227



Part No: SK145-0114-20

Job Qty: 36 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 5/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: IPP REV:A 17.06.06 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	36 Ea		5/18/18	0.00	0.00	Start Up Machining-3		LLL
110	Bandsaw	36 pcs		5/18/18	0.00	1.37	Bandsaw1		Kt 18/05/18
120	MILL Conv	36 pcs		5/18/18	0.00	113.20	MILL-Conv 1 Haas 1		Kt 18/05/18
130	QC	36 pcs		5/18/18	0.00	0.00	QC2 Machining-4		Kt 18/05/18
140	QC	36 pcs		5/18/18	0.00	0.00	QC8 Machining-4		B 18-05-30
142	HandFinish	36 pcs		5/18/18	0.00	2.68	HandFinish1		
144	QC	36 pcs		5/18/18	0.00	0.00	QC7-5		
146	Powdercoat	36 pcs		5/18/18	0.00	1.46	Powdercoat8		
148	QC	36 pcs		5/18/18	0.00	0.00	QC3		
150	Packaging	36 pcs		5/18/18	0.00	0.00	Packaging3-1		
160	QC21-SA	36 Ea		5/18/18	0.00	0.00	QC21		

Part Op 110 - CUT TO LENGTH AS PER DWG

Descriptions: 120 - MILL END AND DRILL HOLE.

146 - ***Mask SK145-0114-25 prior to powdercoat** START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3T1.000W.065	2024T3 Tubing 1" OD x 0.65" Thick	239.9976 ft (6.6666 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3T1.000W.065	240	36	0

Part Specifications

Specifications could not be found.

Plex 5/17/18 8:10 AM Dart.Gagnon.Michelle

M2024T3T1.000W.065
S072325

M2024T3T1.000W.065
S073727

DQA: _____ Date: _____

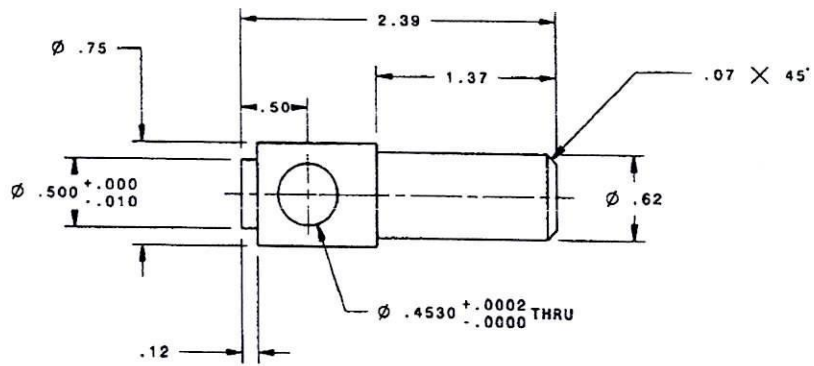
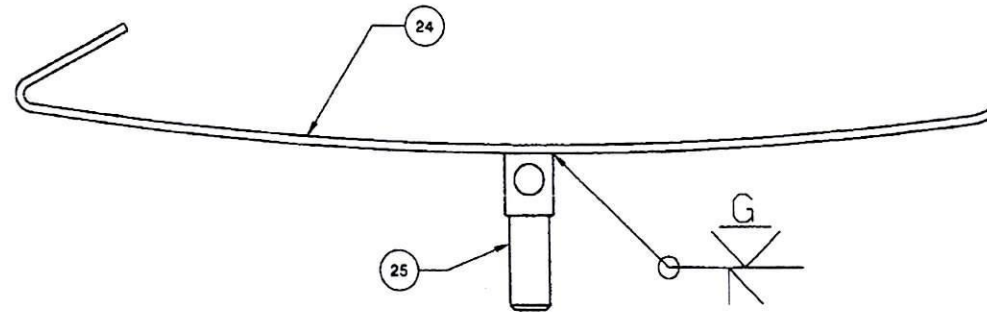


WORK ORDER NON-CONFORMANCE / UPDATE

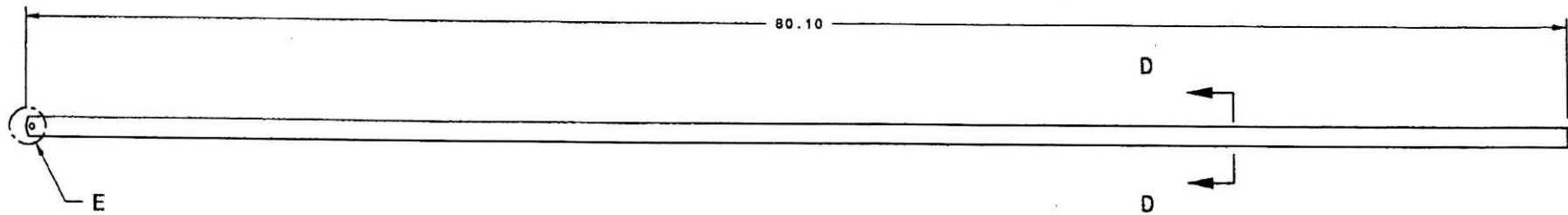
QA Closed: _____ Date: _____

Work Order update only ☐

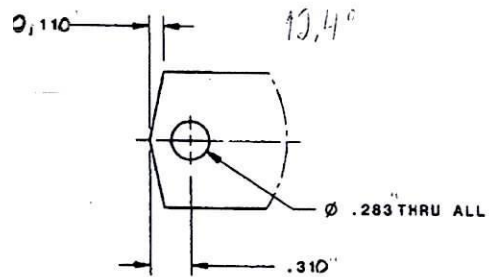
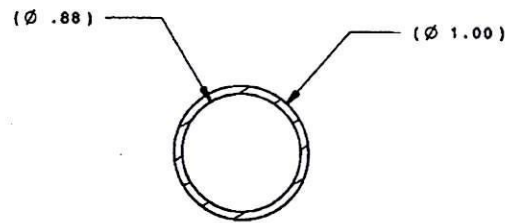
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
						OTHER : ☐	

-25 FITTING

02 HOOK WELDMENT
SCALE: 1:2



-20 TUBE
SCALE: 1:6

DETAIL EVIEW D-D

THE TECHNICAL DATA AND DESIGNS DISCLOSED
HEREIN ARE THE EXCLUSIVE PROPERTY OF AIRBUS
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RIGHTS OF OTHERS AND ARE NOT TO BE USED
FOR FABRICATION OF PARTS WITHOUT PRIOR
WRITTEN CONSENT OF AIRBUS HELICOPTERS, INC.

AIRBUS

CAGE
3GSZ1

DWG NO

SK145-0114

SIZE B

SCALE: 1:1

CATIA

SHEET 3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation			Disposition		
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OTHER : ☐					

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	K.J	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																												
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